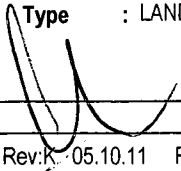
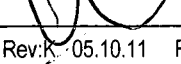


Date: Monday, 10/09/2007 3:35:19 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206L/L3/L4 HIGH GEAR SKID
Job Number : 33171	
Estimate Number : 10525	
P.O. Number : <i>N/A</i>	Part Number : D206642411BL
This Issue : 10/09/2007 S.O. No. : <i>N/A</i>	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : 26/06/2007 Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 33170	Material : <i>N/A</i>
Written By : 	Due Date : 22/07/2007 Qty: 1 Um: Each
Checked & Approved By : 	
Comment : Est Rev: 05.10.11 Revised picklist per CHG004 KJ/CP/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

FSOT.0627
Er 07/09/11

2.0	33171A	206 L HIGH GEAR SKIDTUBE
-----	--------	--------------------------

**Comment:** Sub-Component 206 L HIGH GEAR SKIDTUBED206-642-441 B *B33171A*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D2652	Bushing
-----	-------	---------

**Comment:** Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 D2652 Bushing

1 D206-642-441(REF) *B33234**B33171A**PB*

5.0	D2655	Ring
-----	-------	------

**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D2655 Tow Ring *B33149**PC*

Date: Monday, 10/09/2007 3:35:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 33171

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2659

Lug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2659 Lug Assembly

B34433

C 7/19/11

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

10 D2712

Set Screw

B33667

C

8.0

D29321

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2932-1

Saddle

B32328

C

9.0

D29331

206 Saddle Left



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2933-1

Saddle

B34154

C

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2934

Saddle Spacer

B32235

C

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2935

Saddle Spacer

B33219

C

Date: Monday, 10/09/2007 3:35:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 33171

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29381

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2938-1

Saddle

B 34106

13.0

D29391

206 Saddle Left side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2939-1

Saddle

B 33744

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2968-043

Tow Ring

B 34107

15.0

AN337A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN3-37A

Bolt

M102339

16.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN3-41A

Bolt

M104625

Date: Monday, 10/09/2007 3:35:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 33171

Part Number: D206642411BL

Job Number:



Seq. #: Machine Or Operation: Description :

17.0 AN45A Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN4-5A

Bolt M100850

18.0 AN46A Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt M105057

19.0 AN511A Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN5-11A

Bolt M104746

20.0 AN512A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-12A

Bolt M104156

21.0 AN513A Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN5-13A

Bolt M15928

Date: Monday, 10/09/2007 3:35:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 33171

Part Number: D206642411BL

Job Number:



Seq. #:	Machine Or Operation:	Description :
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22.0	AN960JD10	Washer
------	-----------	--------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

12 AN960JD10

Description Batch

Washer. M104885

23.0	AN960JD1016	Washer
------	-------------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

1 AN960JD1016

Description Batch

Washer M5519

24.0	AN960JD416	Washer
------	------------	--------



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Qty Part Number

25 AN960JD416

Description Batch

Washer M104215

25.0	AN960JD516	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

8 AN960JD516

Description Batch

Washer M1038156

26.0	AN9704	Washer
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

1 AN970-4

Description Batch

Washer M103344

27.0	MS21042L3	Nut
------	-----------	-----



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Qty Part Number

12 MS21042L3

Description Batch

Nut (or -3) M104936

Date: Monday, 10/09/2007 3:35:19 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 33171

Part Number: D206642411BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total: 13.0000 Each(s)

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4)

M104248

7/5/10 ①

29.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

7/9/11

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-411

Location:

PPP Rev:

7/9/11 ①

31.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

7/9/11 ①

Job Completion



U 7-9-11

33171A

44 Blue

Dart Aerospace Ltd.

30

Date: Tuesday, 6/26/2007 3:19:12 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE
 Job Number : 33171A
 Estimate Number : 10522
 P.O. Number : N/A Part Number : D206642441
 This Issue : 6/26/2007 S.O. No. : N/A Drawing Number : D2650 REV E
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : E
 Previous Run : 33170A Material : N/A
 Due Date : 7/22/2007 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : 07.06.27
 Comment : Est Rev. H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JL
 M

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

2.0

D2620

Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2620

Bent Tube 3" OD

B32754 Pw 07-07-24

3.0

D2647

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2647

Fwd Cap

B22228 BE 070724

4.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube Pw 07-07-24

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650 Pw 07-07-24

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M104907/M104221 BE 070724

4-Grind weld flush to cap on top surface only. BE 07-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:19:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 33171A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Cut aft end 138.60" from front of tube

DP 7-7-24

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

Pm 07-07-24

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

Pm 07-07-25

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pm 07-07-25



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

6.0

D26547

206 I Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

B-33216 07/07/27 AWM

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650 (without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

Pm 07-07-25

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 07/07/27 Time: 8:55

Finish Date: 07/07/27 Time: 9:16

A/R Sikaflex-291

Sikaflex expiry date: 01/2008

AWM 07/07/27

DP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:19:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 33171A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 07-07-30

9.0

D2649

Crossbolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

BE 31926

BE 07-07-30

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

m 104221

BE 07-07-30

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

DP 7-7-31

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

B28935

DP 7-7-31

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

103525

DP 7-7-31

13.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

DP 7-7-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:19:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 33171A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 M7885/3-4-3

Rivets

11872

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

DP 2-2-31

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/08/01 ②

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/08/01

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

ml 01 08 29

①

18.0

SPRAY PAINTING

SPRAY PAINTING



Comment: 1-Prime outside as per QSI 005 4.2

Make sure Nut Plate Thread protected use paint screw

2-Paint outside crosstube DELFLEET BLUE

3-CLEAR WITH DELFLEET

ISSUE P.O TO ATELIER DEBOSSELAGE

4496 C267/08/30 ① 07/9/07

19.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

07-09-04 @

20.0

D26483

Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

D32465

07/09/05 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:19:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 33171A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D265615

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

B31113

FL

22.0

D265623

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B32580

FL

23.0

D265637

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B33217

FL

24.0

D34291



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B31037

FL

25.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

or (see QSI 017)

~102475

FL 07/09/05 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:19:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 33171A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

26.0

AN960JD10L

Washer



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

m/04885

FL

27.0

MS27039108

Screw



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 MS27039-1-08

Screw

m/04603

FL

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

B34146

FL

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

B32099

FL

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

~~m/03338~~ *m/03338*

FL

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

FL 07/09/05 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:19:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 33171A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 MS27039-4-06 Screw

M15194

FL

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B34152

FL

33.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 AN960JD10L

Washer

M104885

FL

34.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 MS27039-1-08

Screw

M104603

FL

35.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

M104616

Sikaflex expiry date:

07-09

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650.
Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

M104616

Sikaflex expiry date:

07-09

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch:

M105386

M-1

07/09/06

(1X)

FL
07/09/06 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: 12 Date: 07/09/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 6/26/2007 3:19:12 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 33171A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Wing work
Em 2-9/08

37.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Em 2-9/07

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PAP 33171 6/7/11

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
2-9/11

Job Completion



11 2-9-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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CHECKED <i>PH</i>	APPROVED <i>1/1</i>	DRAWING NO. D2650	REV. E SHEET 1 OF 5
DATE 06.03.30		TITLE 206/407 SKIDTUBE ASSEMBLIES	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.26	AS MANUFACTURED CHANGES	
C	97.10.29	CHANGE HOLE PATTERN AND FRONT END	
D	04.05.17	REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HNDLNG ON D2650-1/-3	
E	06.03.30	RMV C'BORE, CHG DRILL, ADD CHAMFER	

RELEASED
16 04 17 *1/1*

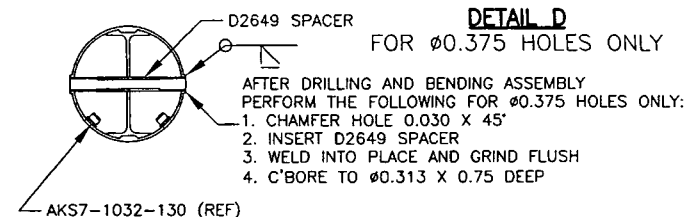
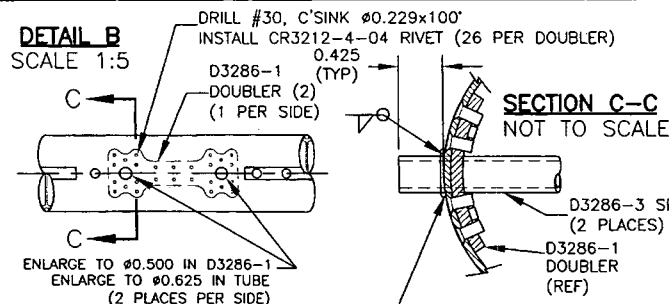
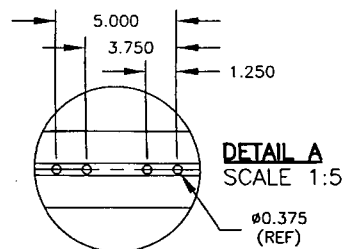
Qty -1	Qty -3	Qty -5	Qty -7	Part Number	Description
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
16	17	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

NOTES

- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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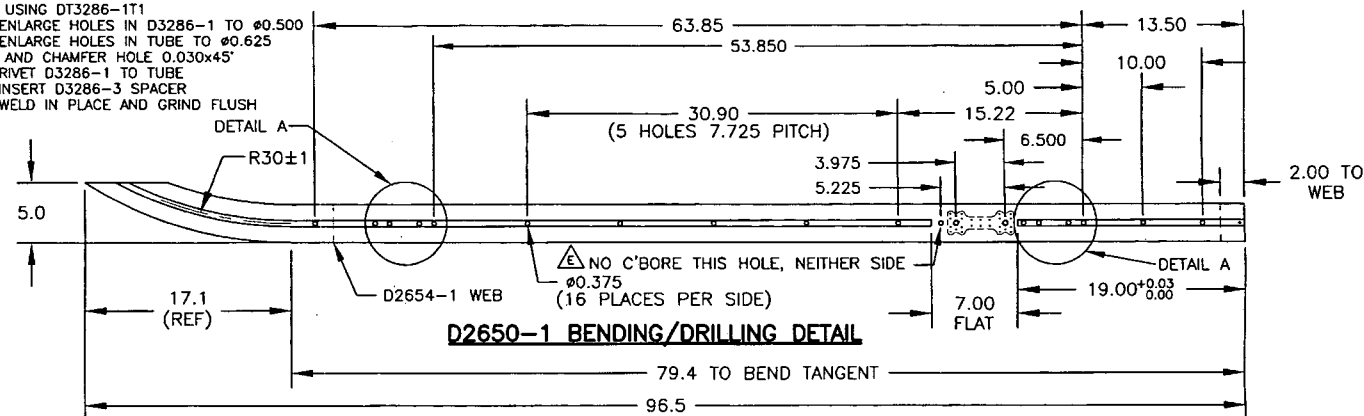
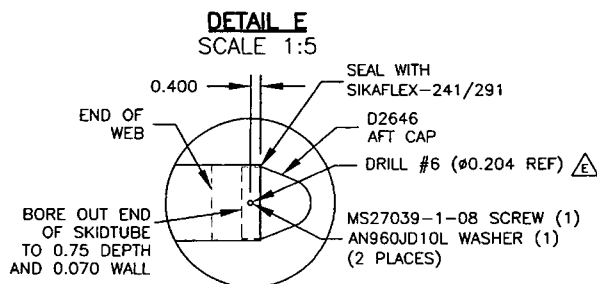
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06.04.17

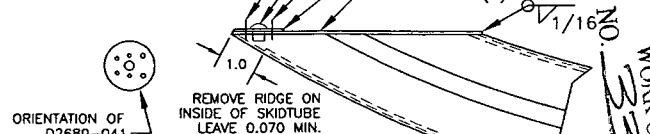
- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

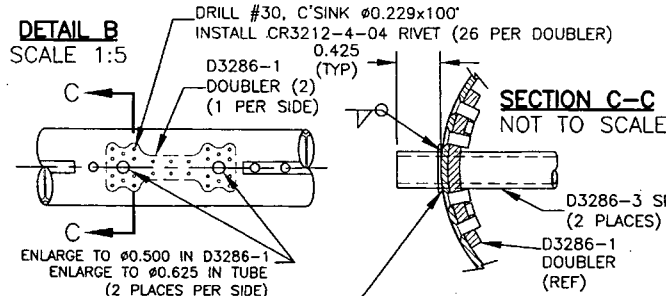
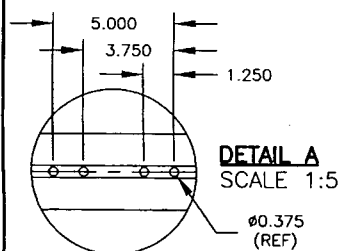
NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



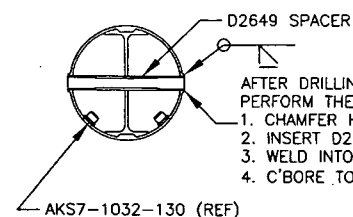
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D2650-1 ASSEMBLY/FINISHING DETAIL

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06.03.30			TITLE	SKIDTUBE	SHEET 2 OF 5
			SCALE		1:10



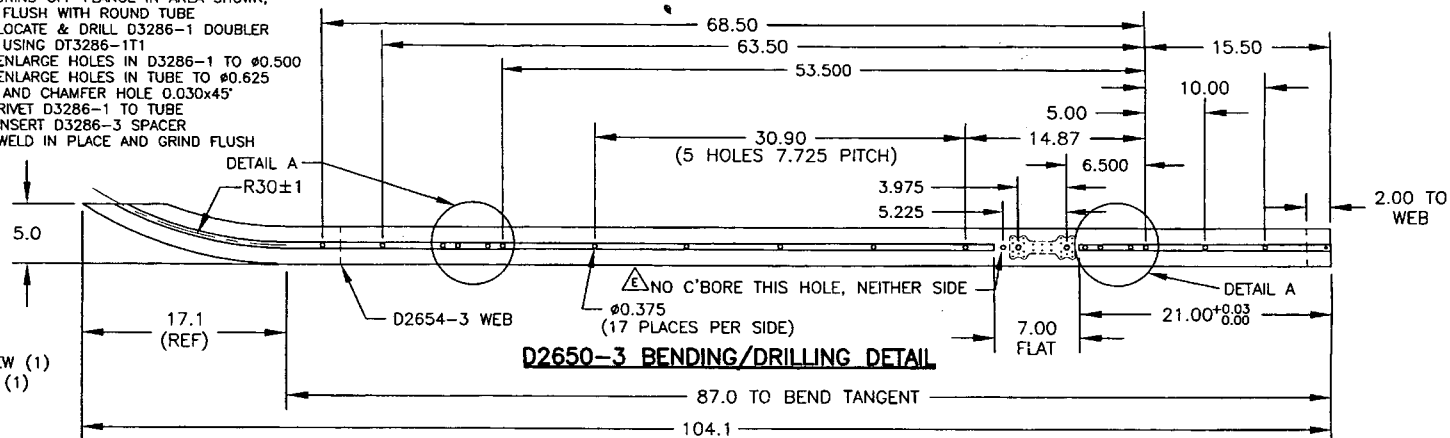
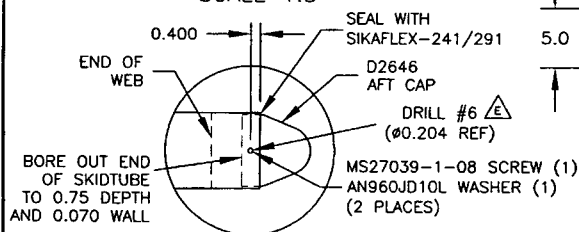
SECTION C-C NOT TO SCALE



RELEASED

- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO $\phi 0.500$
 4. ENLARGE HOLES IN TUBE TO $\phi 0.625$ AND CHAMFER HOLE 0.030x45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

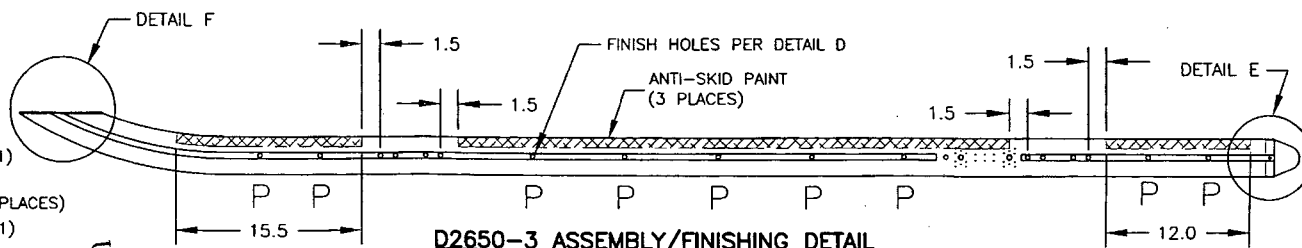
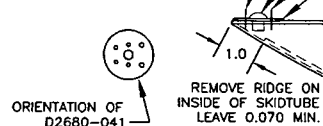
DETAIL E SCALE 1:5



DETAIL F (NOT TO SCALE)

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH



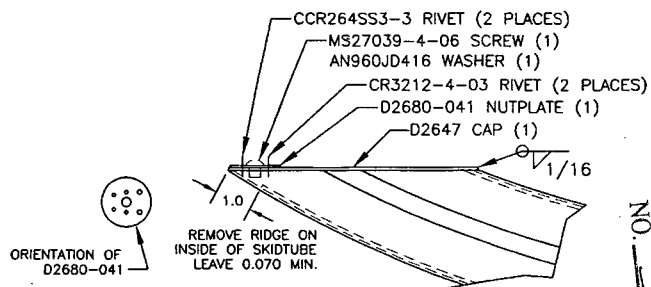
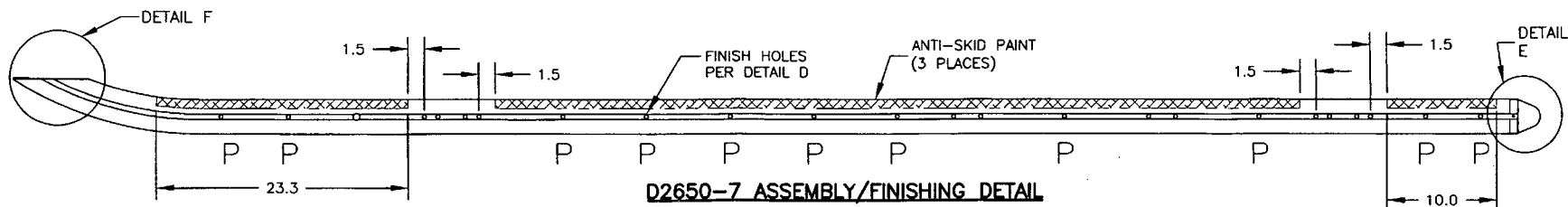
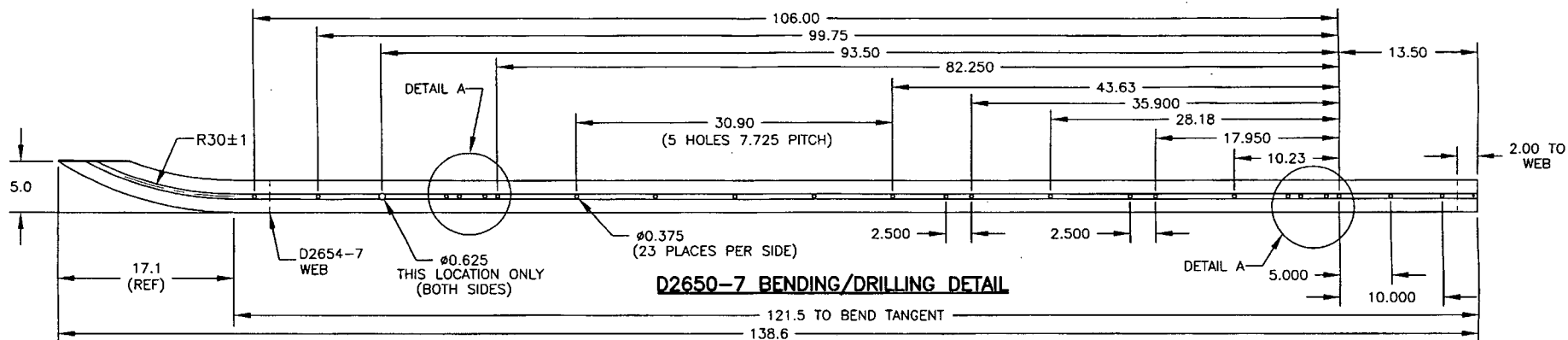
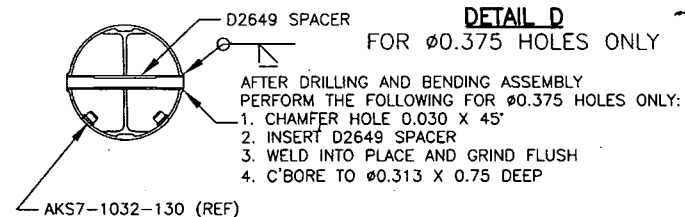
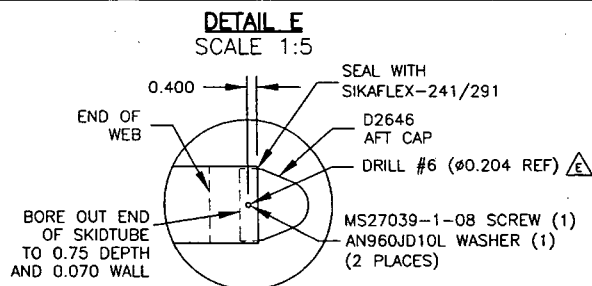
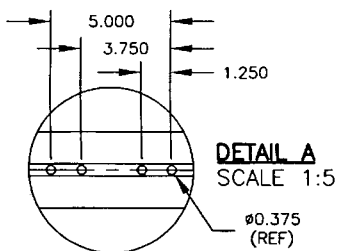
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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA	SHEET 3 OF 5
DATE	06.03.30	DRAWING NO.	D2650	TITLE	SKIDTUBE
				SCALE	1:10

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- DETAIL F (NOT TO SCALE)**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D2647 (TRIM AS NECESSARY)
 4. WELD D2647 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

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RELEASED
06.03.30

NO. 120

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Amir, Ali
Joint Welding Procedure Tig
Part number and Job number 206642541 / 1033021A

TEST WELDS REQUIRED

BASE METAL Alum WELDING PROCESS Tig
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 07/07/30

Qualifier Individual